

Date: Thursday, 04/12/2008 9:10:49 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 43900					
Estimate Number	: 10725					
P.O. Number	:			Part Number	: D2652	
This Issue	: 04/12/2008		S.O. No.	: D2652 REV A		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: MACHINED PARTS		
Previous Run	: 43804			Drawing Revision	: A	
Written By	:			Material	:	
Checked & Approved By	: JUD08.12.05			Due Date	: 21/12/2008	
Comment	: Est Rev:B 02.06.13 Now machined in house.			Qty:	200	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M303R0500	303 Round Bar 0.500"	
		Comment: Qty.: 0.0578 f(s)/Unit Total : 11.5500 f(s) Material: 303 ss .500" Round Bar (M303R0500) Batch: 110252	<p style="text-align: right;">JUD 08/12/2008</p> <p style="text-align: right;">JUD 08/12/16</p>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: 1-TURN AS PER FOLIO FA250 & DWG D2652	<p style="text-align: right;">JUD 08/12/23</p> <p style="text-align: right;">JUD 08/12/16</p>
		FOLIO REV: AA DWG REV: A	<p style="text-align: right;">JUD 08/12/23</p> <p style="text-align: right;">JUD 08/12/16</p>
		2-DEBURR AS REQUIRED	<p style="text-align: right;">JUD 08/12/23</p> <p style="text-align: right;">JUD 08/12/16</p>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<p style="text-align: right;">JUD 08/12/23</p> <p style="text-align: right;">JUD 08/12/16</p>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<p style="text-align: right;">JUD 08/12/23</p>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock: Location: ST/90	<p style="text-align: right;">PJM 08/12/24 (2/2)</p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-22	2.0	- 131 parts are un-acceptable. over tolerance by 0.002-0.004," causing item to be very tight upon installation. R&B Tool wear out during operation, offset was not redone.	25142	<ul style="list-style-type: none"> - Parts are un-acceptable to Shop to customer. Give to Eng. 1st for re-sig set-ups. - Review tool calibration to ensure tool is still within spec - Replaced qty 131 H110252 	08/22 08/22 08/22	08/22	08/12-22	08/12-22

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43900
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>CH</u>	Audited by:	<u>JL</u>	Prototype Approval:	N/A
Date:	09/12/15	Date:	08/12/23	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF	PF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

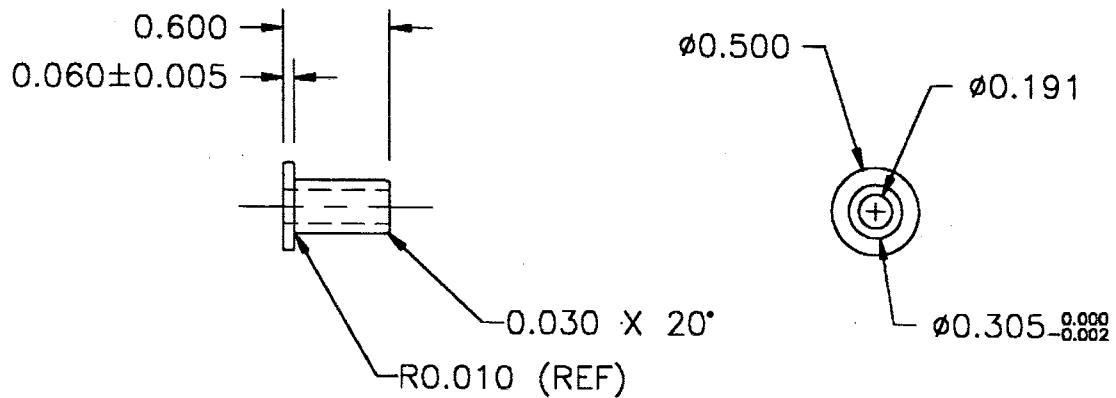
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>MM</i>	DRAWN BY <i>DDY</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>BW</i>	APPROVED <i>DDY</i>	DRAWING NO. D2652	REV. A SHEET 1 OF 1
DATE 97:03:25		TITLE BUSHING	SCALE 1:1

RELEASED
97/04/25 DS



MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART. QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries